

Work Order ID 52651



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October 5, 2009 2:52:40 PM

Item ID: D2617-3

Accept



Setup Start



Revision ID: D2

Stop



Item Name: Bushing

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: *BL*

Date: 09-10-5 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2617	Rev D2								
100		Hardinge CNC LATHE SMALL	0.00	<i>Nov 10/10</i>					
Hardinge		Memo	0.00						
Hardinge CNC Lathe Small		Turn as per Folio FA437 and Dwg D2617							

110		QC2- Inspect parts off machine FAI/FAIB	0.00	<i>Nov 10/10</i>					
Quality Control		Memo	0.00						

120		QC8- Inspect parts - second check	0.00	<i>Nov 09/10/11</i>					
Quality Control		Memo	0.00						

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Item ID: D2617-3

Accept



Setup Start



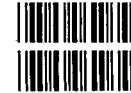
Revision ID: D2

Stop



Item Name: Bushing

Start Date: 06/10/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

2009/10/10

S8

Small Fab

Memo

0.00

Small Fab

Deburr break all unmarked sharp edges 0.005 to 0.010

140



Chemical Conversion Coat per QSI005 4.1

0.00

CMO 09/10/16

Y58

HandFinish

Memo

0.00

Hand Finishing

150



QC5- Inspect part completeness to step on W/O

0.00

S8
09/10/16

QC

Memo

0.00

Quality Control

10.10.16

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Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 39

0.00

9/10/26

Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/19

MF 09-10-19

Picklist Print

Page 1

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Work Order ID: 52651



Parent Item: D2617-3RevD2



Parent Item Name: Bushing

Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	99.5500	1.5347			

6061-T6 RD Tube .375 x.058W

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	99.55	
110485	5.67	
110968	3.67	
111432	10.21	
111944	80	

5.9 RT SH 08/10/11

DART AEROSPACE LTD	Work Order:	52651
Description: Bushing	Part Number:	D2617-3
Inspection Dwg: D2617 Rev: D2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

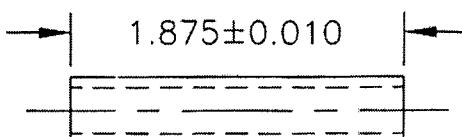
Measured by:		Audited by:		Prototype Approval:	N/A
Date:	09/10/10	Date:	09/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617 REV. D SHEET 1 OF 1
DATE	01.07.04	TITLE	BUSHING	SCALE 1:1
D2 04.09.10 #1P ADD D2617-7	A	96.10.08	NEW ISSUE	
	B	97.05.08	.875 WAS 1.125	
	C	97.06.04	0.369 DIA WAS 0.375	
	D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
	DI	CP-# 04.07.12	CORRECT TOLERANCE (NCR 774)	

D2617-1 (0.375 OD x 0.058 WALL)



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

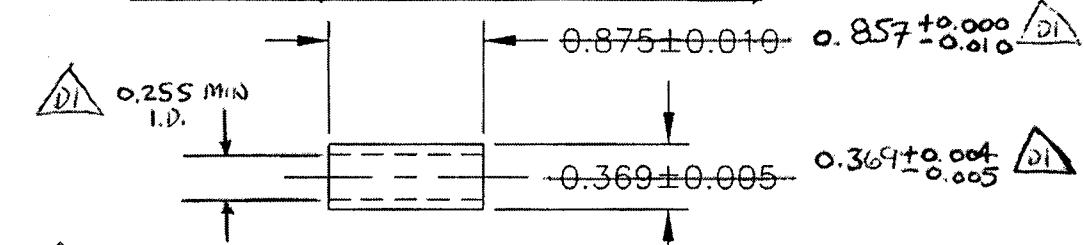
WITHOUT NOTICE

WORK ORDER

NO. 50451

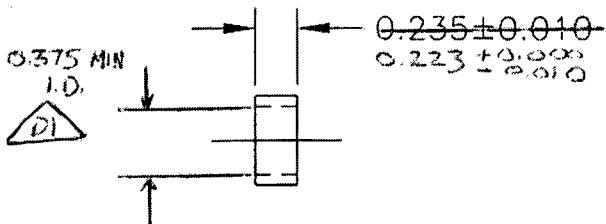
PL 04-10-5

D2617-3 (0.375 OD x 0.058 WALL)



D2617-2 → SAME AS D2617-3, EXCEPT MADE FROM DELRIN (M-DELIN-R)

D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05 #1

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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